

Date: Wednesday, 7/11/2007 2:46:24 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 33472		
Estimate Number	: 10834		
P.O. Number	: N/A	Part Number	: D29332
This Issue	: 7/11/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2933 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33354	Drawing Revision	: C
		Material	: N/A
Written By	: <u>Kim Johnston</u>	Due Date	: 7/30/2007
Checked & Approved By	: <u>Kim Johnston</u>	Qty:	10 Um: Each
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: B31386

J.F. 07/07/16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
5-Deburr

J.L. J.F. 07/07/16

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

J.L. 07/07/18

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L. 07/07/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:46:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 33472

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mr 07/07/19

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-d 07/07/21

10X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 104144

m-d 07/07/21

10X

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Ec 7/7/23

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5742FA*

Ec 7/7/23

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/23

Job Completion



U 07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 33472
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.104"	.120	.120	.118		
B	0.100	0.140		.110"	.119	.120	.117		
C	0.100	0.140		.121"	.122	.118	.122		
D	0.210	0.230		.215"	.220	.218	.116		
E	1.245	1.255		1.251"	1.250	1.250	1.250		
F	1.245	1.255		1.252"	1.250	1.250	1.250		
G	2.495	2.505		2.501"	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.571"	1.577	1.577	1.577		
J	2.495	2.505		2.501"	2.500	2.500	2.500		
K	0.257	0.262		Ø .259"	.259	.259	.259		
L	0.312	0.317		Ø .315"	Ø .315"	.316	.316		
M	0.235	0.240		.240	.238	.239	.239		
N	0.100	0.140		.110"	.115	.114	.116		
O	0.540	0.560		.548"	.550	.550	.550		
P	0.490	0.510		.505"	.501	.501	.501		
Q	3.715	3.725		3.723"	3.720	3.719	3.719		
R	2.470	2.510		2.497"	2.492	2.492	2.492		
S	0.240	0.270		.244"	.253	.251	.251		
T	0.100	0.180		.135"	.135	.135	.135		
U	1.625	1.635		1.633"	1.630	1.630	1.630		
V	1.362	1.372		1.371"	1.367	1.367	1.366		
W	0.316	0.321		Ø .320"	.321	.321	.321		
X	1.125	1.145		1.135"	1.132"	1.130	1.131		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575	1.573	1.573		
Z	0.178	0.198		A.188"	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F. 1 / J.L.
Date:	07/07/16 / 07/07/17

Audited by:	Jul
Date:	07/07/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	33472
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.120	.122	.123	.123		
B	0.100	0.140		.120	.121	.123	.122		
C	0.100	0.140		.120	.123	.123	.122		
D	0.210	0.230		.219	.220	.220	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.238	.238	.239		
N	0.100	0.140		.117	.120	.119	.119		
O	0.540	0.560		.548	.549	.549	.548		
P	0.490	0.510		.501	.501	.501	.501		
Q	3.715	3.725		3.720	3.720	3.719	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.250	.250	.250	.252		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.131	1.137	1.138	1.134		
Y	1.565	1.585	DT8695 A/B	1.572	1.577	1.577	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>JL</i>	Audited by: <i>[Signature]</i>
Date: 07/07/17	Date: 07/07/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 33472
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

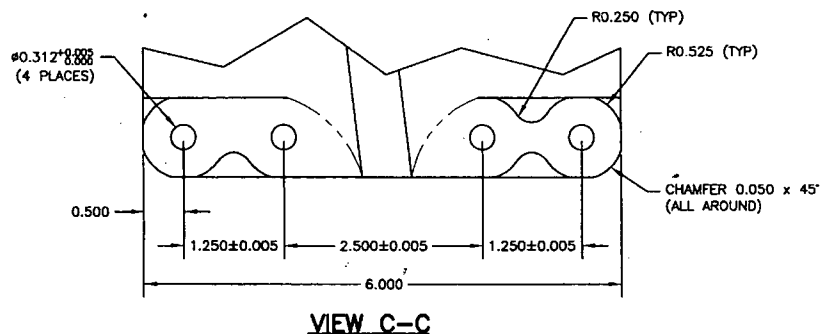
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.123	.123				
B	0.100	0.140		.123	.123				
C	0.100	0.140		.123	.122				
D	0.210	0.230		.220	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.513	.513				
I	1.572	1.582		1.576	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.316	.316				
M	0.235	0.240		.238	.239				
N	0.100	0.140		.118	.118				
O	0.540	0.560		.547	.548				
P	0.490	0.510		.503	.502				
Q	3.715	3.725		3.719	3.720				
R	2.470	2.510		2.492	2.492				
S	0.240	0.270		.251	.251				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.321	.321				
X	1.125	1.145		1.136	1.134				
Y	1.565	1.585	DT8695 A/B	1.545	1.545				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.
Date: 07/07/17

Audited by: JML
Date: 07/07/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

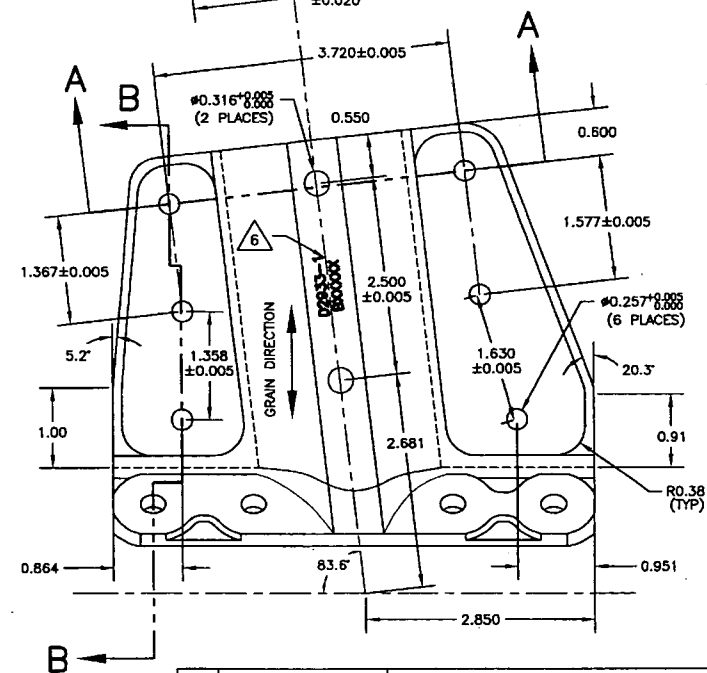
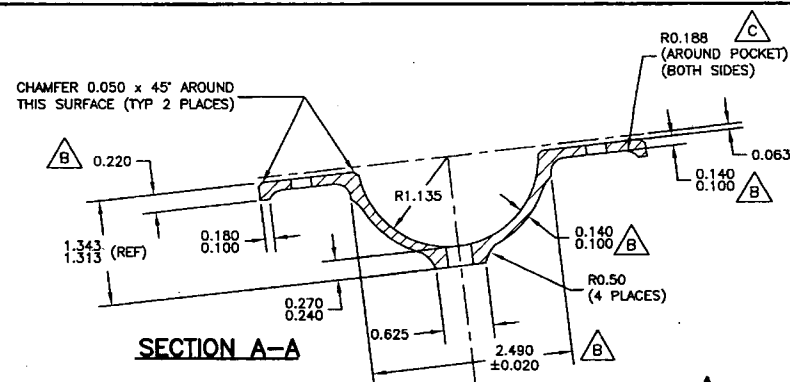
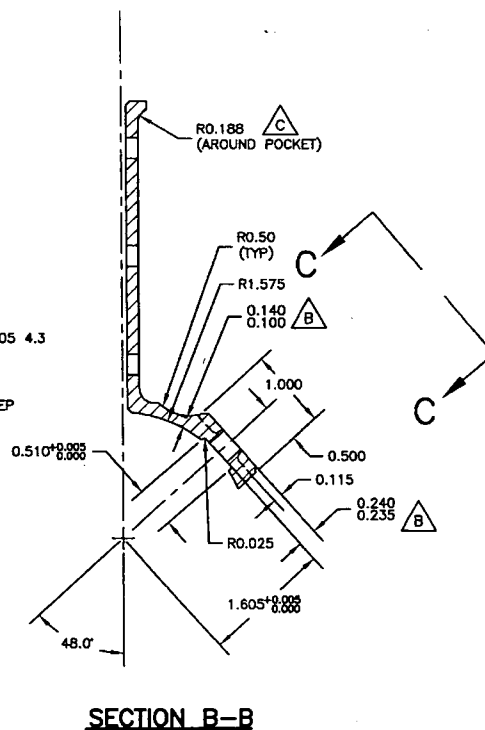


D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO 33472
 07.02.12



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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